



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3121-141
Job Sheet 175489

May 6
SOLD May 6



Part No: D3121-141

Job Qty: 12 ea

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/5/18

Job Tracking No:

Due Date: 5/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP Rev:Pick:A 04.02.18 New issue KJ/DS IPP Rev:B ECN 1060 07-11-12 DD verified by: EC
IPP Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		5/4/18	0.00	0.00	Start Up Machining-1		<i>MLL</i>
100	Bandsaw	12 pcs		5/4/18	0.00	1.36	Bandsaw1		<i>MLL</i>
110	CNC Vertical Machining	12 pcs		5/5/18	0.47	23.53	HAAS1-3		<i>MLL</i>
120	QC	12 pcs		5/5/18	0.00	0.00	QC2 Machining-1		<i>MLL</i>
130	QC	12 pcs		5/5/18	0.00	0.00	QC8 Machining-1		<i>MLL</i>
140	Small Fab	12 pcs		5/7/18	0.00	0.34	Small Fab-2		<i>MLL</i>
150	QC	12 pcs		5/7/18	0.00	0.00	QC5		<i>MLL</i>
160	Packaging	12 pcs		5/7/18	0.00	0.00	Packaging3-1		<i>MLL</i>
170	QC21-SA	12 Ea		5/7/18	0.00	0.00	QC21		<i>MLL</i>

Part Op 100 - Cut blanks: (1.250" x 2.000") 6.600" long

Descriptions: 110 - 1-Machine D3121-111 as per Folio FA361 and Dwg D3121 Identify as D3121-111 3-Scribe batch number

140 - Assemble D3121-141 as per Dwg D3121.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-B1.250X2.000	17-4 SS Bar 1.250 x 2.00	6.6000 ft (.55 ea)	90-Start up Operation	
D3121-21	Bolt	12 Ea (1 ea)	140-Small Fab	
D3121-241	Bearing Assembly	12 Ea (1 ea)	140-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-B1.250X2.000	7	10	0
140-Small Fab	D3121-21	12	67	0
	D3121-241	12	21	0



Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S068410



Part: D3121-141

Job No: 175489

Serial No/Batch: S068410

Revision:

Inspector:

Date: 05/03/18

Specifications

Specifications could not be found.

Plex 4/5/18 2:15 PM Dart.lajeunesse.marie

M17-4-B1.250X02.000
S030457

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DART AEROSPACE LTD		Work Order: 175489
Description: Bracket		Part Number: D3121-111
Inspection Dwg: D3121	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	0.3935	✓		Kt-01	micrometre.
0.75	+/-0.030	0.750	✓		Kt-05	verm.
0.375	+/-0.010	0.375	✓		" "	" "
2.14	+/-0.030	2.140	✓		" "	" "
1.96	+/-0.030	1.962	✓		" "	" "
0.280	+/-0.010	0.275	✓		" "	" "
3.330	+/-0.010	3.330	✓		" "	" "
3.630	+/-0.010	3.628	✓		" "	" "
R0.25	+/-0.030	0.250	✓		—	R-G
R0.375	+/-0.010	0.375	✓		—	R-G
Ø0.201	+/-0.010	0.201	✓		Kt-05	verm.
0.100	+/-0.010	0.100	✓		" "	" "
4.580	+/-0.010	4.570	✓		" "	" "
6.18	+/-0.030	6.18	✓		31006	H-G
5.89	+/-0.030	5.89	✓		" "	H-G
0.080	+/-0.010	0.080	✓		Kt-05	verm.
0.300	+/-0.010	0.300	✓		" "	" "
30°	+/-0.1°	30°	✓		91C-17	R-G
R0.25	+/-0.030	0.250	✓		—	R-G
0.130	+/-0.010	0.131	✓		Kt-05	verm.
0.664	+/-0.010	0.664	✓		31006	H-G
0.381	+/-0.010	0.381	✓		Kt-05	verm.
0.201	+/-0.010	0.201	✓		" "	" "
0.400	+/-0.010	0.397	✓		" "	" "
0.580	+/-0.010	0.580	✓		" "	" "
100°	+/-0.1°	100°	✓		" "	" "
0.032	+0.000/-0.010	0.032	✓		" "	" "

Measured by:	Audited by: 20 9-89	Preliminary Approval:
Date:	Date: 18-05-07	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue P/O D3121-141	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	
D	08.01.16	Dimensions updated per Dwg Rev. E	KJ/EC/DD	
E	08.05.28	Tolerance revised for Ø0.201 dimension	KJ/DD	
F	13.10.22	Tolerance revised for Ø0.201 dimension	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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						Completed By															
						Lead hand / Supervisor Approval Verification															
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